

Work Order ID 55237

January 12, 2010 1:31:28 PM



Page 1

Item ID: D4052-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Eye Bolt

Start Date: 1/12/10 Start Qty: 2.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *PL*

Date: *10-1-12*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4052

PA1

0.00

100



Doosan

Memo

0.00

Doosan Lathe

TURN AS PER FOLIO FA892 AND DWG
DWG REV: *N/A PAI*
FOLIO REV: *N/A*

SL 10/01/20

DEBURR

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 10/01/20

(2)

Memo

0.00

Quality Control

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

⇒ 8106117

QC

Memo

0.00

(12)

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

AS. Prototype
test
10-01-30

U 1002.08

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

January 12, 2010 1:31:43 PM

Work Order ID: 55237



Parent Item: D4052-1



Parent Item Name: Eye Bolt

Start Date: 1/12/10

Required Date: 1/25/10

Comments: IPP REV:A NEW ISSUE 10-01-07 JLM VERIFIED BY:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M303R0.750

Purchased

No

100

f

199.8000

0.3939



303 Round Bar 0.750

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

199.8

107077

0

113134

51.1

113295

12.1

113365

84.7

113424

51.9

4/10

SL 10/01/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

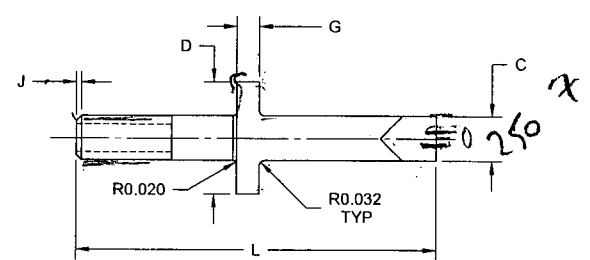
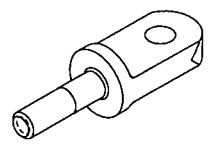
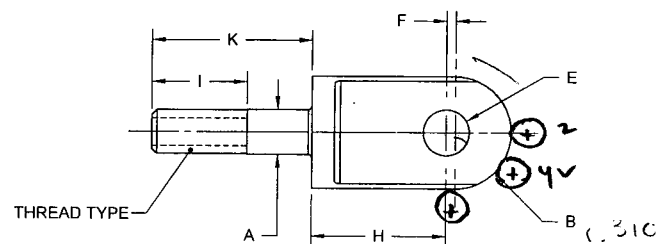
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

14.8 ↓
 14.375 < 2 →
 14.188 < 2 ←
 14.188 < 2 →
 14.375 ←
 14.8 < 2
 14.8
 ↑



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 55237

PL 101-13

D4052-X EYE BOLT

P/N	THREAD TYPE	A	B	C	D	E	F	G	H	I	J	K	L
D4052-1	1/4-28 UNF-3A	$\phi 0.249^{+0.000}_{-0.003}$	R0.31	0.25	$\phi 0.63$	$\phi 0.257$	0.050	0.125	0.75	0.531	0.03	0.89	2.01

PRELIMINARY ISSUE

09.12.11

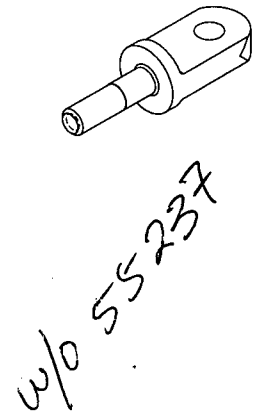
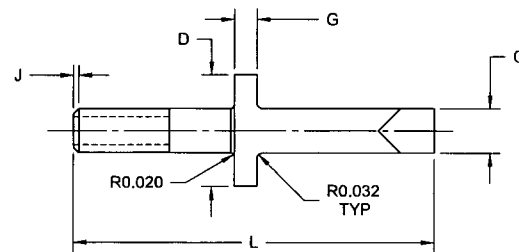
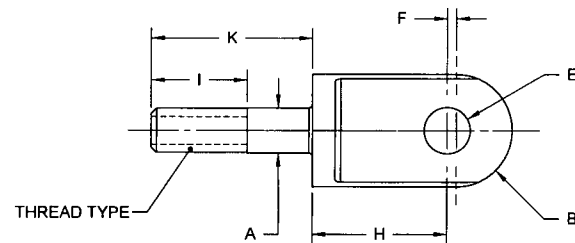
- NOTES:
- 1) MATERIAL: AISI 303 STAINLESS STEEL, ROUND BAR
PER DART SPEC M303R
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.06 lbs

PA1	NEW ISSUE	RF	09.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4052	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		EYE BOLT	NTS
DATE	09.12.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

140 each side
 350

2-2.198

266
 1690



D4052-X EYE BOLT

P/N	THREAD TYPE	A	B	C	D	E	F	G	H	I	J	K	L
D4052-1	1/4-28 UNF-3A	$\phi 0.249^{+0.000}_{-0.003}$	R0.31	0.25	$\phi 0.63$	$\phi 0.257$	0.050	0.125	0.75	0.531	0.03	0.89	2.01

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